

Work Order ID 52799

October 14, 2009 10:48:43 AM

Page 1

Item ID: D3321-3

Accept

Revision ID: B

Item Name: Wearplate, Aft End

Start Date: 10/14/2009 Start Qty: 12.00

Required Date: 10/21/2009 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MF

Date: 09-10-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3321

Rev B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3321

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control



(PE) ->

B 9-10-14

(25)

113 9-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3321-3 PAR #: 10-004 Fault Category: ENG-DWG NCR: Yes No DQA: 18 Date: 10.01.21
 Resolution: Acceptable Disposition: use as is QA: N/C Closed: 18 Date: 10.01.26

NCR: <u>52799</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
21/01/14	100	During inspection Found that all (Qty 25) Parts have the obround to obround max/min 2.932, should be 2.954. The PAI also has the Dims as correct.	CP 09.11.02 per 08/04/2	Scrap and destroy all 25 parts Reprogram ACCEPTABLE 09.11.02		CP 09.11.02	CP 09.11.02 per 08/04/2	S 09/10/21
		2.6. parts are not measured correctly AND Program is wrong	CP 09.11.02 per 08/04/2	Fix Program & make correct PARTS ACCEPTABLE PARTS MATCH DXF & DWG GEOMETRY. PARTS FIT SKID. DWG DIM ERROR	N/A	CP 09.11.02	CP 09.11.02 per 08/04/2	S 09/10/21
				open PAR to fix DWG.				

NOTE: Date & initial all entries

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Date:

Run Start

Stop

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Draw
Rev.

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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Inspect dimensions as per inspection template D3321-3T1

CP 09.10.21

140

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1- Form using DT8179 Die & DT8774 as per Dwg D3321Rev: B
2- FORM JOGGLE USING DT8753

802/11/17

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

802/11/17

25
25
EFFECTIVE 09.10.21
RELEASED CP DATE 09.11.02

CHECK BENT SHAPE ON
TUBE. → OK CP 09.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 52799

October 14, 2009 10:48:43 AM



Item ID: D3321-3

Accept



Setup Start



Revision ID: B

Item Name: Wearplate, Aft End

Stop



Start Date: 10/14/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/21/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
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Number

Draw
Rev.

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Reject
Qty

Reject
Number

Insp.
Stamp

160

Weld per dwg A/R Hardcoat steel Batch: M113078 0.00
Large Fab



Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3321-3T3 as per QSI 004 and Dwg D3321

1/SP 09 12 04 25X

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

=> QC10-80-12/04
=> QC5-80-12/04

counter
425

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588-

Memo

0.00

Powder Coating

START TIME: 3:40
OVEN TEMPERATURE: 320°
FINISH TIME: 4:10

BR 09-12-8 25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

54560 DRU

Work Order ID 52799



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Setup Start



Revision ID: B

Item Name: Wearplate, Aft End

Stop



Start Date: 10/14/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/21/2009 Req'd Qty: 12.00



Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
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Draw
Number

Draw
Rev.

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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

M 09/12/09

(425) 0



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: _____

0.00

Packaging



Packaging

Memo

0.00

Packaging

9/12/11 (25) 50

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/14

M 09/12/11 (25)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October 14, 2009 10:48:42 AM

Page 1

Work Order ID: 52799

Parent Item: D3321-3RevB

Parent Item Name: Wearplate, Aft End

Start Date: 10/14/2009

Required Date: 10/21/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	101.9400	2.7966	5.8262		



1010/1025 sheet 16GA



B9-10-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111410

101.94

101.94

111410

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

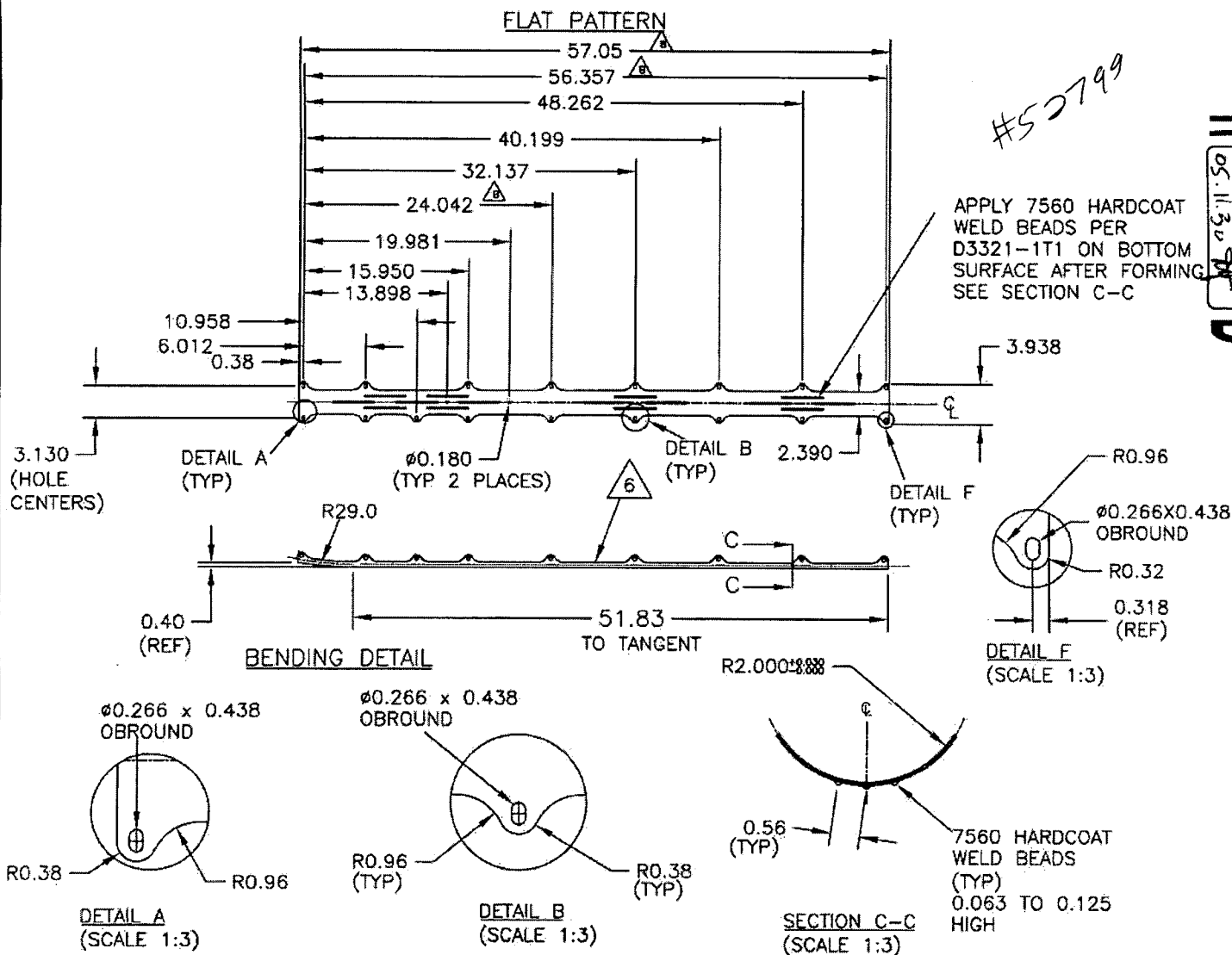
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

05.11.30 *fr*

05.11.31

APPLY 7560 HARDCOAT
WELD BEADS PER
D3321-1T1 ON BOTTOM
SURFACE AFTER FORMING
SEE SECTION C-C



D3321-1 WEARPLATE (SHOWN, -2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN PH		DRAWING BY PH		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3321		REV. B	
DATE 05.04.29		TITLE WEARPLATE		SHEET 1 OF 2	
A	04.10.01	NEW ISSUE		SCALE 1:15	
B	05.04.29	ADJUST GEOMETRY			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

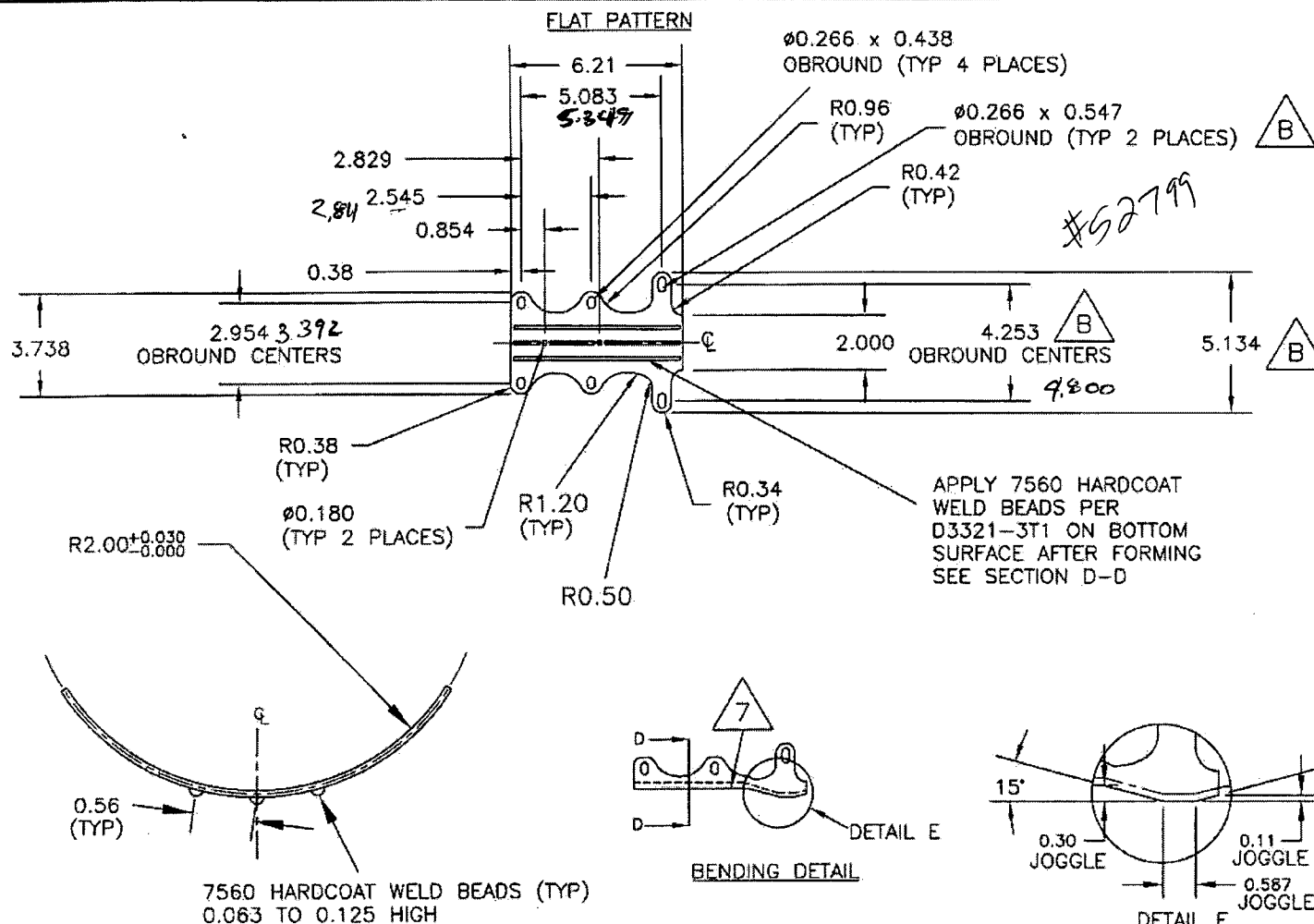
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



SECTION D-D
(SCALE 1:1.5)

D3321-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
05.11.30

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.04.29	TITLE	D3321	REV. B
WEARPLATE				SHEET 2 OF 2
				SCALE 1:6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries